

FED. SUPPLY CLASS

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AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC.
1000 WILSON BLVD.
ARLINGTON, VA 22209

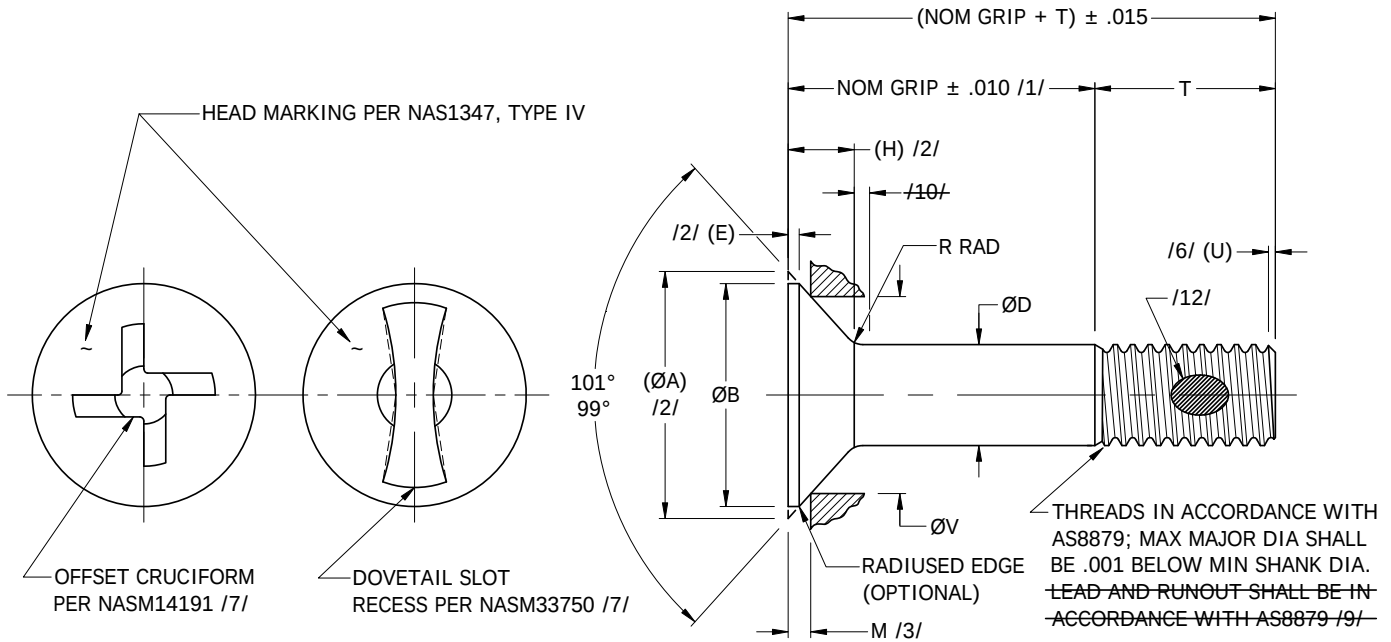


TABLE I – DIMENSIONS AND STRENGTH VALUES

FIRST DASH NO.	THREAD	(ØA) /2/	ØB	ØD	(E) /2/	(H) /2/	M GAGE PROT /3/	R RAD	T	(U) /6/	ØV GAGE	Y FIM /4/	Z FIM /5/	DOVETAIL SLOT RECESS /7/			
		MAX	MIN		MAX									RECESS NO.	J	(K)	(W)
04	.1120-40 UNJC-3A	.225	.194	.1115 .1095	.012	.049	.0227 .0193	.012 .005	.232	.050	.1720 .1718	.005	.0040	1	.030 .026	.190	.084
06	.1380-32 UNJC-3A	.279	.244	.1375 .1355	.014	.060	.0255 .0195	.012 .005	.276	.050	.2195 .2193	.005	.0040	1	.043 .039	.225	.088
08	.1640-32 UNJC-3A	.332	.294	.1635 .1610	.015	.072	.0278 .0195	.015 .005	.338	.050	.2671 .2669	.005	.0040	2	.053 .050	.265	.100
3	.1900-32 UNJF-3A	.385	.344	.1895 .1870	.016	.083	.0302 .0232	.015 .005	.338	.050	.3147 .3145	.005	.0040	3	.045 .042	.305	.110
4	.2500-28 UNJF-3A	.507	.461	.2495 .2470	.018	.110	.0343 .0273	.015 .005	.425	.060	.4245 .4243	.006	.0030	4	.054 .051	.422	.134
5	.3125-24 UNJF-3A	.635	.583	.3120 .3095	.020	.139	.0412 .0322	.020 .010	.469	.060	.5389 .5387	.008	.0030	5	.064 .061	.490	.160
6	.3750-24 UNJF-3A	.762	.703	.3745 .3720	.023	.166	.0466 .0366	.020 .010	.578	.080	.6532 .6530	.009	.0025	6	.088 .084	.639	.198

12 COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 12
PROCUREMENT SPECIFICATION NOTED	TITLE BOLT, 100° FLUSH HEAD, SELF-LOCKING OPTIONAL	CLASSIFICATION PART STANDARD
		NAS1221 SHEET 1 OF 6

TABLE I – DIMENSIONS AND STRENGTH VALUES (CONTINUED)

FIRST DASH NO.	RECESS TORQUE LBF-IN MIN		DOUBLE SHEAR STRENGTH LBF MIN		TENSILE STRENGTH LBF MIN /19/	
	A286-CRES ALLOY STEEL TITANIUM	302-OR 305-CRES	CRES ALLOY STEEL TITANIUM	302-OR 305-CRES	CRES ALLOY STEEL TITANIUM	302-OR 305-CRES
04	19	15	1,840	1,320	925	720
06	27	22	2,805	2,000	1,400	1,100
08	42	34	4,010	2,830	2,170	1,700
3	58	50	5,380	3,800	3,180	2,480
4	125	110	9,300	6,570	5,790	4,500
5	200	176	14,600	10,270	9,260	7,220
6	380	334	21,000	14,800	14,000	10,900

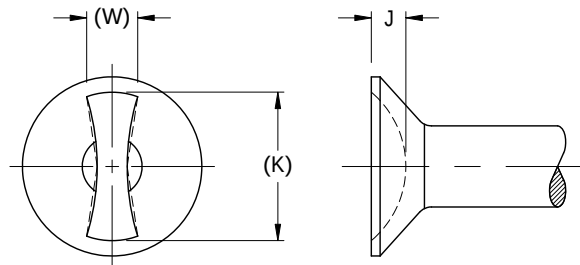
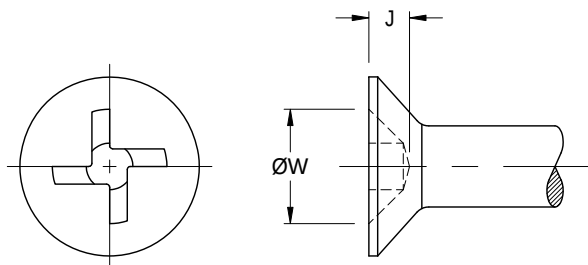


TABLE II – OFFSET CRUCIFORM RECESS

FIRST DASH NO.	RECESS NO.	J MAX	ØW MAX	GAGE PENETRATION		RECESS TORQUE LBF-IN MIN	RAISED METAL INCH MAX
				MAX	MIN		
04	4	.055	.148	.0405	.0305	13	.005
06	6	.066	.182	.0500	.0395	30	.005
08	8	.078	.215	.0595	.0480	50	.005
3	10	.090	.248	.0685	.0560	60	.005
4	1/4	.118	.325	.0890	.0750	140	.005
5	5/16	.122	.357	.0860	.0700	220	.005
6	3/8	.145	.427	.1030	.0850	520	.006

TABLE III – DOVETAIL SLOT RECESS

FIRST DASH NO.	RECESS NO.	J		(K)	(W)	RECESS TORQUE LBF-IN MIN	RAISED METAL INCH MAX
		MAX	MIN				
04	1	.030	.026	.190	.084	13	.005
06	1	.043	.039	.225	.088	30	.005
08	2	.053	.050	.265	.100	50	.005
3	3	.045	.042	.305	.110	60	.005
4	4	.054	.051	.422	.134	140	.005
5	5	.064	.061	.490	.160	220	.005
6	6	.088	.084	.639	.198	520	.006

MATERIAL:

ALLOY STEEL - 4140 (UNS G41400) PER MIL-S-5626 AMS6382, 4340 (UNS G43406) PER AMS6415 OR AMS6484, 4340 (UNS G43406) PER MIL-S-5000, OR 8740 (UNS G87400) PER MIL-S-6049 AMS6322, AMS6325 OR AMS6327.

CRES - A286 (UNS S66286) CONFORMING TO THE CHEMISTRY OF AMS5731, AMS5732, AMS5737 OR AMS5853.
- 302-CRES, CONDITION B OR 305-CRES PER QQ-S-763.

TITANIUM ALLOY - 6AL-4V (UNS R56400) PER AMS4928 OR AMS4967.

LOCKING ELEMENT NYLON OR EQUIVALENT.

HEAT TREAT:

DEVELOP BASIC MATERIAL PROPERTIES AS FOLLOWS, WITH CONTROLS PER AMS2759 FOR ALLOY STEEL AND CRES AND AMS-H-81200 OR AMS2801 FOR TITANIUM.

ALLOY STEEL: 160-180 KSI Ft_u
CRES: 160-190 KSI Ft_u. PRECIPITATION HARDENING PER AMS5853. /19/
302-OR 305-CRES 125,000 PSI MINIMUM TENSILE STRENGTH
TITANIUM (6AL-4V): 160 KSI Ft_u MIN

REVISION

12

NAS1221

SHEET 2

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